

FOREIGN FILES

FABRICA NACIONAL DE MONEDA Y TIMBRE

MADRID

1975- *only*

877
X - Mr. S. D'Amato
New York

E.H.W.
FEB 25 1975

H. V. D.
APR 16 1975

11th February, 1975.

Dear Chauncey,

2/10/75
Enclosed please find the report of our visit to Madrid. As you requested, I have sent another copy to Sal and of course David Hare has one.

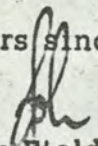
I hope you had a safe journey home and that your shopping expedition on Friday morning was satisfactory.

As always we enjoyed having you here and felt that your visit was certainly beneficial to our operations. I assume that in due course you will send us a copy of your report as you did on the last occasion.

You asked me to remind you of the request I had received from India concerning the possibility of their attending one of the Bank Note Printers Conferences. According to Michael Cabbage the Bank Note Printers Conference itself would not be open to India in view of their geographical location, so if there is anything you can do through Jim Conlon to facilitate their being invited to the Pacific Rim Conference, then I would certainly appreciate it, and I am sure it would go a long way to help our efforts with the people in Delhi.

Once again thank you for all your help and advice during the last two weeks.

Yours sincerely,


John Field

Mr. C.P. Foote

10th February, 1975.

FILING

APR 11 1975

Visit to Fabrica Nacional De Moneda Y Timbre
by Mr. C.P. Foote and Mr. J.B. Field accom-
panied by Sr. Victor Hernando - B.W. Agent

Hosts: Senor G.G. Calderon - Director
Senor L. Gimeno - Dep. Director

Presses in the plant:

- 3 old 2-plate Glori
- 5 new style 4-plate Intaglio (not Super)
 - 1 machine 11 months old
 - 1 machine 14 months old
 - 2 machines 2-3 years old
 - 1 machine 4 years old

From the arrival at the plant of the presses in crates to production takes $2\frac{1}{2}$ months.

Speed:

- 3 machines running at 4,700 - 4,800 iph
- 1 machine running at 5,300 iph (on 100 Pesetas banks)

Wiping Method:

Two of the old machines were working on trichlorethylene. The remaining old machine and all the new presses were set up for water wipe.

1. Standard diameter wiping cylinders of this vintage of Glori 4-plate intaglio presses.

2. 2 squeegees - one hard at 0° to roller and one very soft at angle approximately $1\frac{1}{2}^{\circ}$ below hard squeegee.

3. The wiping tank appeared to be exactly as we saw it in Brazil - see S. D'Amato for details of same.

4. An ink saving roller was being used on all newer presses, but not on the three old ones.

a) On the 1000 Pesetas face they were capturing the brown ink - possibly to condition the portrait image which is in the brown so as to obtain a better rendering.

/...

b) On other presses they were capturing either two or three inks and reworking some later into darker shades.

(One press which was about two years old had a Churchill Control Unit for flow/cooling/heating rather than Brazil piping system)

c) Ink saving unit was a composition (rubber) covered roller followed by a chrome roller.

Delivery:

All presses were functioning with the classic interleaving system.

While they have Giori de-interleaving equipment, they have rejected the method in favour of male hand de-interleaving at a rate of 17 reams in 7½ hours of work. There were approximately 20 males involved. The Deputy Director commented that they also achieve an accurate count.

In no instance have they successfully stacked work without an interleaving sheet. This answer was given without qualification as to the number of sheets in the stack. In May or June this year SICPA will demonstrate a system in Lausanne for stacking of water wipeable intaglio inks.

Inspection:

On the 1000 value they achieved regularly 78% good full sheets plus 16% with minor defects which were treated as acceptable and not segregated.

The work inspectors (male) also had been trained to make two other categories of inspection - significant part waste (which was reinspected and then cut up to provide make up notes), and a fourth category which was total waste.

Manufacture of PVC rollers for plate wiping:

PVC rollers may have one, two, or three coatings - the implication was clear that they only concerned themselves with diameter of roll and if achieved in one layer O.K. Shore "A" gauge was used to measure hardness 24 or more hours after coating. Standard is 80 pts.

No coating between rubber and PVC is required or used.

Soon after coating roller but before it had developed 80 Shore "A" hardness the surface was "rectified" on a grinding wheel. This is followed by a 3 step orbital sanding operation (before full hardening achieved) to give roller final dull surface for maximum wiping.

Records are kept indicating the life of cleaning rollers and this varies from a minimum of 11 reams to a maximum of approximately 1,000 reams before recoating is necessary.

Intaglio Printing Plates:

Electrolytic plates are obviously being used. These have a very short life mainly due to plates fracturing at the nose or tail. Normally plates do not last long enough to be re-chromed more than twice, but there are plates which fail after 20 or 25 reams. 500 reams would be regarded as an exceptional plate life.

Water Wiping Solution:

Approximately 10% caustic soda
Approximately 2-5% sulphanated castor oil
in water

Temperature of solution in wiping cylinder vat is 40°C.

Offset Equipment:

2 colour Roland presses are currently used but some time within the next 2-3 years Calderon would like to install a blanket to blanket perfecting machine.

Plates used for offset printing are magnesium. Plate life of over 1,000 reams is common place.

cc: Mr. E. H. Weitzen ✓

E.H.W.
FEB 20 1975

February 19, 1975

Dear John:

FILING

FEB 11 1975

Visit to Madrid
Your Feb. 11 letter to Chauncey

If you keep up this sort of nonsense we may have to give you a technical degree of some kind.

Several points within the report raise some interest and question in my mind.

Item 1: I assume the ink saving roller you mentioned is the new version of the geared unit now being put on all new Giori water wipe presses.

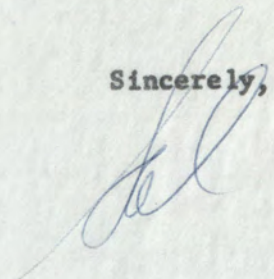
Item 2: Their failure on electrolytic plates seems horrendous. Do they attribute this to the condition of the nickel, or is this a function of the press cylinder design on the nose and tail?

Item 3: The water wipe solution seems quite heavy in its percentage to caustic (10%). Without going to the files, my memory indicates that Giori's solution called for 2% caustic plus 2% of sulphanated castor oil. Is there any reason why they are using such a high caustic content?

The answers to these questions are not imperative, so that I would not want you to make further inquiries to Madrid unless your relationships permit same.

Thanks again for the report.

Sincerely,



Mr. J. Field
New Malden

E.H.W.
MAR 10 1975

W.R.B.
MAR 12 1975

FILING

4th March, 1975.

MAR 11 1975

Dear Sal,

Visit to Madrid

Thank you for your letter of 19th February. Whilst I am happy to accept any kind of technical degree, especially if no expenditure is involved, I think on this occasion the honours must really go to Chauncey, since he wrote out by hand the greater part of our report whilst we were together in Madrid, and only gave it to me so that Christine could check the spelling'.

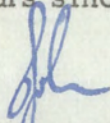
No doubt you have asked Chauncey for further details on the points which interest you and I hope that the following ties up with his interpretation of the situation.

1. I do not know when the new version of the geared inking unit first featured on a Giori water wipe press, but apparently all the presses had been delivered with this unit supplied as standard, and I certainly could not myself see any differences from press to press. On the other hand, the second cylinder did appear to be a chromed cylinder whereas David Hare's report on his visit to Germany mentioned a ceramic cylinder in this location, so maybe there is some choice offered to users of these presses.
2. They were certainly pretty embarrassed about the life of their electrolytic plates and during our conversation they definitely contributed it to the design of the nose and tail on the plate cylinders. On the other hand, to be perfectly fair, it was hardly the sort of conversation in which they would have admitted any failings in their own electrolytic deposition procedures. What was obvious from the records that they showed me was that this was not a sudden deviation from the standard; the failure rates which were quoted in the report were typical of those going back over quite a long period in their records.

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3. I agree that the water wipe solution seems heavy in its caustic percentage and certainly the 2% you have mentioned is much more typical of a Giori installation. I had a look at a report of my previous visit to see if I mentioned this point, but apparently we did not discuss it at that time and the only detail I noted was that the solution temperature was 40°C, the same as it was when Chauncey and I were there. I prefer not to go back to ask the question about the percentage of caustic in the solution, but I certainly agree with you that it seems excessively high and therefore probably anomalous.

Yours sincerely,

A handwritten signature in blue ink, appearing to be 'John Field', written over the typed name.

John Field

Mr. S. D'Amato
New York